



AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of the claims in the application:

LISTING OF CLAIMS

1. (Currently Amended) A shank end mill, comprising:

a shank and a cutting part disposed at a front end of the shank and defining an axis of rotation;

an outer periphery of the cutting part therein cutting grooves extending helically to a front end face of the cutting part, wherein main cutting edges extend along an edge of the cutting grooves;

the end face including end-face cutting edges formed by an intersection of the end face with respective walls of the grooves, said end-face cutting edges are arranged substantially in a common plane;

wherein a portion of each cutting groove disposed rearwardly of the end face defining a helix angle with a plane containing the axis, the helix angle being larger than a cutting-face angle formed between ~~the end face and~~ a front end section of each cutting groove and the longitudinal axis of the shank end mill;

the cutting-face angle continuously transforming into the helix angle;

wherein the transition from the front end section of each cutting groove forms a sharp cutting edge with the front end face of the cutting part.

2. (Previously Presented) The shank end mill according to claim 1 wherein the cutting-face angle transforms into the helix angle along a constant radius of curvature.

3. (Previously Presented) The shank end mill according to claim 1 wherein the cutting-face angle transforms into the helix angle along a plurality of radii, including a first radius adjoining the cutting edge, and a second radius adjoining the helix angle, the first radius being smaller than the second radius.

4. (Previously Presented) The shank end mill according to claim 3 wherein the cutting-face angle has a negative value, and each groove forming a zero-degree angle and then a positive angle while transforming into the helical angle.

5. (Previously Presented) The shank end mill according to claim 1 wherein a transition between the cutting-face angle and the helix angle extends substantially parallel to the axis for a distance shorter than a diameter of the tool.

6. (Previously Presented) The shank end mill according to claim 5 wherein a transition between the cutting-face angle and the helix angle extends substantially parallel to the axis for a distance shorter than one-half a diameter of the tool.

7. (Previously Presented) The shank end mill according to claim 1 wherein the end face and the outer periphery are joined by a chamfer, the chamfer having an axial extension shorter than an axial extension of a transition from the cutting-face angle to the helix angle.

8-10 (Canceled).

11. (Withdrawn) A process for the manufacture of a rotary cutting tool, the rotary cutting tool comprising a shank and a cutting part disposed at a front end of the shank and defining a first axis of rotation; the process comprising shaping a helical groove in an outer periphery of the cutting part by the steps of:

A) rotating an abrasive disc about a second axis of rotation;

B) engaging the rotating disc against the outer periphery of the cutting part at a location rearwardly of a front end face of the cutting part with the first axis inclined relative to the front axis;

C) rotating the cutting part about the first axis during step B;

D) producing relative axial movement between the disc and the cutting part in a direction parallel to the first axis during steps B and C whereby the disc approaches the front end face, along a helix angle; and

E) tilting the disc continuously when the disc reaches a position adjacent the front end face, wherein the groove forms a continuously reducing helix angle toward the front end face.

12. (Withdrawn) The process according to claim 11 wherein the abrasive disc forms the helical groove during steps A-E.

13. (Withdrawn) The process according to claim 11 wherein the abrasive disc finishes a preformed groove during steps A-E.

14. (Withdrawn) The process according to claim 11 wherein a ratio between the relative axial movement and the rotational velocity of the cutting part has a first value during steps A-D, and a second value during step E, wherein the second value is greater than the first value.